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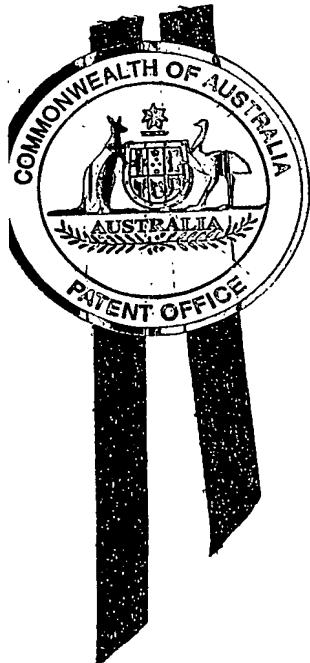
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I, JULIE BILLINGSLEY, TEAM LEADER EXAMINATION SUPPORT AND SALES hereby certify that annexed is a true copy of the Provisional specification in connection with Application No. 2003901436 for a patent by BHP STEEL LIMITED as filed on 27 March 2003.



WITNESS my hand this
Seventh day of April 2004

JULIE BILLINGSLEY
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PROVISIONAL SPECIFICATION

Applicant(s):

BHP STEEL LIMITED
A.C.N. 000 011 058

Invention Title:

ROLL FORMER FOR PRECAMBERED METAL SECTIONS

The invention is described in the following statement:

FORMING APPARATUS FOR PRECAMBERED METAL SECTIONS

Technical Field

5 The present invention relates to an apparatus for and method of, forming a metal section from sheet metal strip. The invention has been developed especially for roll forming metal profiles such as metal decking and the invention is herein described in that context. The
10 invention however has broader application and is not limited to that particular use.

Background of the Invention

15 Composite structures formed from metal decking on which a concrete slab is cast are commonly used in building. Typically, the decking is installed on site so as to span supporting elements, such as columns or walls. The decking includes a pan section and upstanding edge
20 regions which are in abutting relationship so as to form a continuous surface. Concrete is cast over the surface so that the upstanding edges are embedded in the slab. The metal decking therefore acts both as formwork for casting of the slab, and also provides tensile strength to the
25 structure on curing of the slab.

In the applicants' earlier International applications, PCT/AU01/01446, and PCT/AU01/01447, an improved metal decking is disclosed which incorporates a
30 precamber in the longitudinal direction of the decking. The purpose of the precamber is to compensate for deflection of the decking on casting of the slab thereby enabling the decking to span greater lengths without exhibiting excessive deflection of the composite
35 structure. The decking in these earlier applications also discloses an improved edge interlock arrangement which further improves the strength of the composite structure.

Whilst metal decking according to the above form has improved performance, difficulties have been encountered in incorporating the precamber into the metal section.

5

Summary of the invention

An aim of the present invention is to provide an arrangement where a precamber can be introduced into a
10 metal section.

Accordingly, in a first aspect invention relates to a method of roll forming a metal section from sheet metal strip comprising of the steps of;

15 - differentially stretching the metal strip in its longitudinal direction so that at least one portion of the metal strip is more elongated than a laterally adjacent portion of the strip;

- roll forming the differentially stretched metal strip to
20 form a profiled section; and

- bending the profiled section so as to introduce a longitudinal precamber in the profiled section.

An advantage of the present invention is that the
25 profile and precamber can be introduced into the section in a single pass. Furthermore, the method can be easily introduced into an existing roll forming line merely by including additional processing stations.

30 The applicants have found that by preconditioning the metal strip through differential prestretching, the amount that the metal section can be bent without buckling of the section, or introducing significant areas of weakness in the metal section, can be significantly increased.

35

In a preferred form, the elongated portion(s) of the strip extend continuously in a longitudinal direction of

the strip.

In a preferred form, the elongated portion(s) are aligned in areas of the metal strip which are subjected to significant bending during the roll forming of the profiled section. In this way, the differential stretching is designed at least in part to compensate for the tendency of some metal sections to bow as a result of the roll forming of the metal strip. Traditionally, in formation of a metal section having a generally C profile, the metal section tends to bow inwardly in the same direction as the flanges of the section extend. This is caused by foreshortening of the metal strip as a result of roll forming the flanges of the C section.

15

In an embodiment of the invention, the metal strip is of a generally C shape having upturned edges which extend from one face of the strip. Further, the differential stretching is designed to compensate at least in part for the tendency of the metal strip to bow and furthermore, the bending of the profiled section is about the face opposite to that in which the upturned edges of the section extend.

25

In one embodiment, the metal strip is roll formed so as to be differentially stretched.

30

In a preferred form, the profiled section is caused to bend about a fulcrum to introduce the longitudinal precamber. In one embodiment, the profiled section is restrained upstream from the fulcrum and is caused to be deflected from the roll forming line downstream of the fulcrum. In this arrangement, a three point bending process is formed to introduce the longitudinal precamber.

35

In one form, the apparatus to shear the profiled section into discrete lengths is used as part of the three

point bending process. Preferably, the shearing apparatus is adjustable so that it can be set to cause the profiled section to be deflected from the general line of the roll former. In that arrangement, the metal section at the

5 shearing apparatus is inclined to the line of the roll forming. In a preferred form, the cutting surface of the shearing apparatus can be similarly inclined so that the shearing action remains perpendicular to the metal section.

10 In a further aspect, the invention relates to an apparatus for forming a metal section from sheet metal strip, the apparatus comprises:

stretching apparatus which is operative to

15 differentially stretch the metal strip in its longitudinal direction so that at least one portion of the metal strip is more elongated than a laterally adjacent portion of the strip;

rollforming apparatus operative to roll form the

20 differentially stretched to form a profiled section; and

bending apparatus operative to bend the profiled section so as to introduce a longitudinal precamber in the profiled section.

25 In a further aspect, the present invention relates to a shear assembly for use cutting a profiled metal section, the shearing assembly comprising an assembly frame, a shearing block attached to the frame and operative to receive the profiled metal section, and a cutting element

30 which is moveable relative to the shearing block; wherein the shearing assembly is height adjustable so that the relative height of the shearing block can be adjusted and the angle of the cutting element relative to the frame can be adjusted.

35 It is convenient to herein after describe an embodiment of the present invention with reference to the

accompanying drawings;

In the drawings;

5 Figure 1 is a schematic perspective view of metal decking for use in a composite structure;

 Figure 2 is a schematic side view of an apparatus performing the metal section of figure 1;

10 Figure 3 is a detailed perspective view of a prestretching apparatus in the system of figure 2;

 Figure 4 is a front elevation of the prestretching apparatus of figure 3;

 Figure 5 is a side elevation of the prestretching apparatus of figure 3;

15 Figure 6 is a front elevation of a reaction station in the rollforming system of figure 1; and

 Figure 7 is a front elevation of the fulcrum station of the system of figure 1.

20 Detailed description of the preferred embodiment

As shown in figure 1, a metal decking 10 is disclosed which is elongated and of generally C-section profile including a pan 12 and a pair of upstanding edge margins 25 14, 16 respectively. The metal decking member 10 in use is interconnected with a like member so as to form metal decking. The metal decking is designed to have cast onto it a concrete slab which embeds the upstanding edge margins 14 and 16.

30

Each of the upstanding edge margins 14 and 16 include an inwardly directed portion 22, 24 which includes a respective lip return 26, 28 which is turned back towards or disposed generally parallel to its opposite edge 35 margins.

The edge margins 14 and 16 also include respective

longitudinally extending ribs 30 and 32. These longitudinal ribs are configured so that adjacent ribs of adjacent decking members interlock to prevent vertical and lateral separation of the metal decking members 10. This 5 interlocking of the ribs eliminates the need for fasteners to secure adjacent decking members together. In the embodiment shown, the ribs interlock through their complimentary shape so that one of the ribs 30 resides within the other rib 32 of a decking member.

10

In addition, the pan 12 of the metal decking member 10 is longitudinally precambered about a bottom face 34 of the pan 12. The precamber of the web is about 0.6% measured as the maximum longitudinal offset of the pan 12 15 from a substantially flat plane and it is expressed as a percentage relative to the length of the member 12. In a typical arrangement, the decking member 10 is supplied in 6 metre lengths, and the maximum offset located in the middle of the member 10 is about 35 mm.

20

In use, concrete is cast on an upper face 36 of the pan 12. Under the load of the cast concrete, the member 10 is caused to at least partly deflect towards the flat plane under the significant weight of this concrete. The 25 advantage of this longitudinal precamber is that it minimises the deflection from a flat line of the metal decking once the concrete slab has been cast. As the maximum deflection is a criteria for determining the span lengths of the metal decking member 10, it allows the 30 limit of the span length criteria to be extended. Another limiting factor on the span length is the strength at the interlock of the adjoining upstanding region between adjacent decking members. The use of the ribs 30 and 32 increases the strength at this interlock. As a result of 35 the precamber and the increased strength at the interlock, the metal decking member 10 is able to span to about 5 metres unsupported as compared to spans of 3 metres for

conventional decking member without a longitudinal precamber.

Figures 2 to 7 illustrate a roll former 50 to make
5 the decking member 10 from sheet metal strip 100. The roll former 50 both shapes the section and incorporates the precamber.

The roll former 50 includes a series of 27
10 rollforming stages (generally designated 51) which shapes the decking member 10. These rollforming stages are not the subject of the invention and are therefore not illustrated in any detail. The roll former 50 includes an additional prestretching apparatus 52, and bending
15 apparatus 53 which precamber the member 10 and which are disclosed in more detail below.

Turning firstly to the prestretching apparatus 53 which is best illustrated in Figures 3 to 5. The
20 apparatus 53 is constructed as a single stage device 54 and is located upstream from the rollforming stages 51. The purpose of the device 53 is to differentially stretch the strip 100 so that it includes longitudinally extended portions 101, 102 which are more elongated than a mid
25 section of the strip 103. The elongated portions 101, 102 are located adjacent the edge margins of the strip 100 in the area where the strip is subjected to maximum bending during the rollforming stages 51. This device is designed to precondition the strip 100 so as to inhibit its
30 tendency to bow about the upper face 36 of the metal decking member 10 which would otherwise occur during the rollforming stages 51. This tendency to bow upwardly is caused by a relative foreshortening of the edge margins caused in forming the upstanding edge margins 14, 16 of
35 the member 10.

The prestretching device uses rollers 55, 56, 57, 58

and 59 to differentially stretch the strip 100. These rollers are configured in a two over three arrangement and are designed so that they are disposed in the vicinity of the longitudinal edge margins of the strip 100. Further, 5 each roller is tapered (as best illustrated in figure 4) so that the amount of stretching varies across each roller.

On exiting the prestretching device 54, the strip 100 10 is then fed into the rollforming stages 51. After passing through the rollforming stages 51, the shaped metal profile 10 is then introduced into the bending apparatus 53 which bends the member 10 about its lower face 34.

15 To bend the member 10, a three point bending process is used which requires that the bending apparatus 53 includes three separate stages; a reaction stage 60, a fulcrum stage 61, and an action stage 62. With this arrangement, the product is arranged to be bent around the 20 fulcrum stage 61 whilst being supported in the reaction stage 60. The action stage is height adjustable so that it can be located below the line of the other stages of the roll former (51, 52, 60 and 61) so as to introduce the bend into the member 10. The amount of bending is dependent on 25 the amount the action stage 62 is offset from the line of the other stages of the roll former 50.

Figure 6 illustrates the reaction stage 60 in more detail. In that stage the member 10 is well supported 30 with the web 12 being captured between an infill roll 63 and floating block 64. The upper end 22, 24 of the upstanding margins 14 and 16 are in engagement with upper rollers 65 and 66. This arrangement enables the profile 10 to be well supported and in particular to resist any 35 lifting of the web 12.

Figure 7 illustrates the fulcrum stage 61. During

this stage, the member 10 is designed to introduce the precamber into the member 10. This is achieved by allowing the member 10 to bend about the infill roll 66. In addition the infill roll in the illustrated form 5 incorporates a tapered surface which tapers from a mid point 68. This tapered roller introduces a lateral precamber across the web 12 as illustrated in figure 7. In the fulcrum stage 61, the upper edges 22 and 24 of the metal deck are not constrained as was the case in the 10 reaction roller 60. This allows the necessary movement of the profile as it introduces the required precamber.

The action stage 62 is best illustrated in figure 1. In the illustrated form, the action stage is incorporated 15 as part of the shear assembly which is operative to cut the member 10 into discrete lengths. In the illustrated form, the action stage 62 includes a cutting block 68 which is mounted on a frame 69. The cutting block 68 is designed to hold the metal section 10 and the frame 69 is 20 height adjustable so that the position of the cutting block can be adjusted so as to introduce the necessary degree of precamber into the metal section 10.

As a result of setting the cutting block 58 at a 25 different height to the other roll forming stages the member 10 located within the cutting block is not exactly parallel within the block 68. The shear assembly 62 also includes a cutting element 70. This cutting element 70 is able to be angularly adjusted relative to the cutting 30 block 68 so that the angle of shear of the cutting element is along a line that is perpendicular to the product 10.

Accordingly, the rollforming apparatus 50 provides a system where the metal strip can be profiled and 35 precambered in a single pass. Furthermore the additional functionality of the roll former 50 to enable the precamber can be easily introduced into an existing

rollforming line merely by including additional stages. Furthermore by preconditioning the metal strip through differential prestretching, the amount the metal section can be bent at the bending stage is increased without the
5 risk of buckling of the section or introducing significant areas of weakness. With this arrangement, it is possible to introduce precambers in the order of 6% as advantageously used in the decking member 10.

10 Variations and modifications may be made to the parts previously described without departing from the spirit or ambit of the present invention.

THE CLAIMS DEFINING THE INVENTION ARE AS FOLLOWS:

1. A method of roll forming a metal section from sheet metal strip comprising of the steps of;
 - 5 - differentially stretching the metal strip in its longitudinal direction so that at least one portion of the metal strip is more elongated than a laterally adjacent portion of the strip;
 - roll forming the differentially stretched metal strip to 10 form a profiled section; and
 - bending the profiled section so as to introduce a longitudinal precamber in the profiled section.
- 15 2. A method according to claim 1, wherein the elongated portion(s) extend continuously in a longitudinal direction of the metal strip.
- 20 3. A method according to claim 1 or claim 2, wherein the elongated portions(s) are aligned in areas of the metal strip which are subjected to significant bending during roll forming of the profiled section.
- 25 4. A method according to any preceeding claim, wherein the profiled section is of a generally C-shape having a pan section and upturned edges which extend from one face of the strip, and wherein the profiled section is bent about the face opposite to that in which the upturned edges of the profiled section extend.
- 30 5. A method according to any preceeding claim, wherein the metal strip is roll formed so as to be differentially stretched.
- 35 6. A method according to any preceeding claim, wherein the profiled section is caused to bend about a fulcrum to introduce the longitudinal precamber.

7. A method according to claim 6, wherein the profiled section is restrained upstream of the fulcrum, and is caused to be deflected from the line of the roll formers downstream of the fulcrum.

5

8. A method according to claim 7, wherein the profiled section is cut into discrete lengths downstream of the fulcrum, a shearing assembly which also causes the profiled section to be deflected from the line of the roll formers.

10

9. An apparatus for forming a metal section from sheet metal strip, the apparatus comprising;

stretching apparatus which is operative to differentially stretch the metal strip in its longitudinal direction so that at least one portion of the metal strip is more elongated than a laterally adjacent portion of the strip;

roll forming apparatus operative to roll form the differentially stretched strip to form a profiled

20 section; and

bending apparatus operative to bend the profiled section so as to introduce a longitudinal precamber in the profiled section.

25 10. A forming apparatus according to claim 9, wherein the stretching apparatus includes at least one roll which is operative to engage a portion of the metal strip so as to elongate the engaged portion of the strip.

30 11. A forming apparatus according to claim 10, wherein the roll has a tapered surface so as to vary the amount of stretching across said engaged portion of the metal strip.

35 12. A forming apparatus according to any one of claims 9 to 11, wherein the bending apparatus comprises a multiple stage device which is operative to introduce a three point bend to said profiled section.

13. A forming apparatus according to claim 12, wherein
the bending apparatus includes a reaction stage operative
to restrain the metal profile, a fulcrum stage about which
5 the profiled section bends, and an action stage which is
operative to induce a load on said profiled section so as
to deflect the profiled section from the line of said roll
formers.

10 14. A forming apparatus according to claim 13, wherein
the action stage is incorporated as part of the shearing
assembly which is operative to cut said profiled section
in discrete lengths.

15 15. A forming apparatus according to claim 14, wherein
the shearing assembly comprises an assembly frame, a
shearing block attached to the frame and operative to
receive the profiled metal section, and a cutting element
which is moveable relative to the shearing block, wherein
20 the shearing assembly is height adjustable so that the
relative height of the shearing block can be adjusted so
as to cause said profiled section to be deflected from the
line of the roll formers.

25 16. A forming apparatus according to claim 15, wherein
the angle of the cutting element to the frame can be
adjusted.

17. A shearing assembly for use in cutting a profiled
30 metal section into discrete lengths, the shearing assembly
comprising an assembly frame, a shearing block attached to
the frame and operative to receive the profiled metal
section, and a cutting element which is moveable relative
to the shearing block, wherein the shearing assembly is
35 height adjustable so that the relative height of the
shearing block can be adjusted, and wherein the angle of
the cutting element relative to the frame can be adjusted.

18. A shearing assembly according to claim 17, wherein
the cutting element is pivotally mounted to the shearing
block.

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Dated this 27th day of March 2003

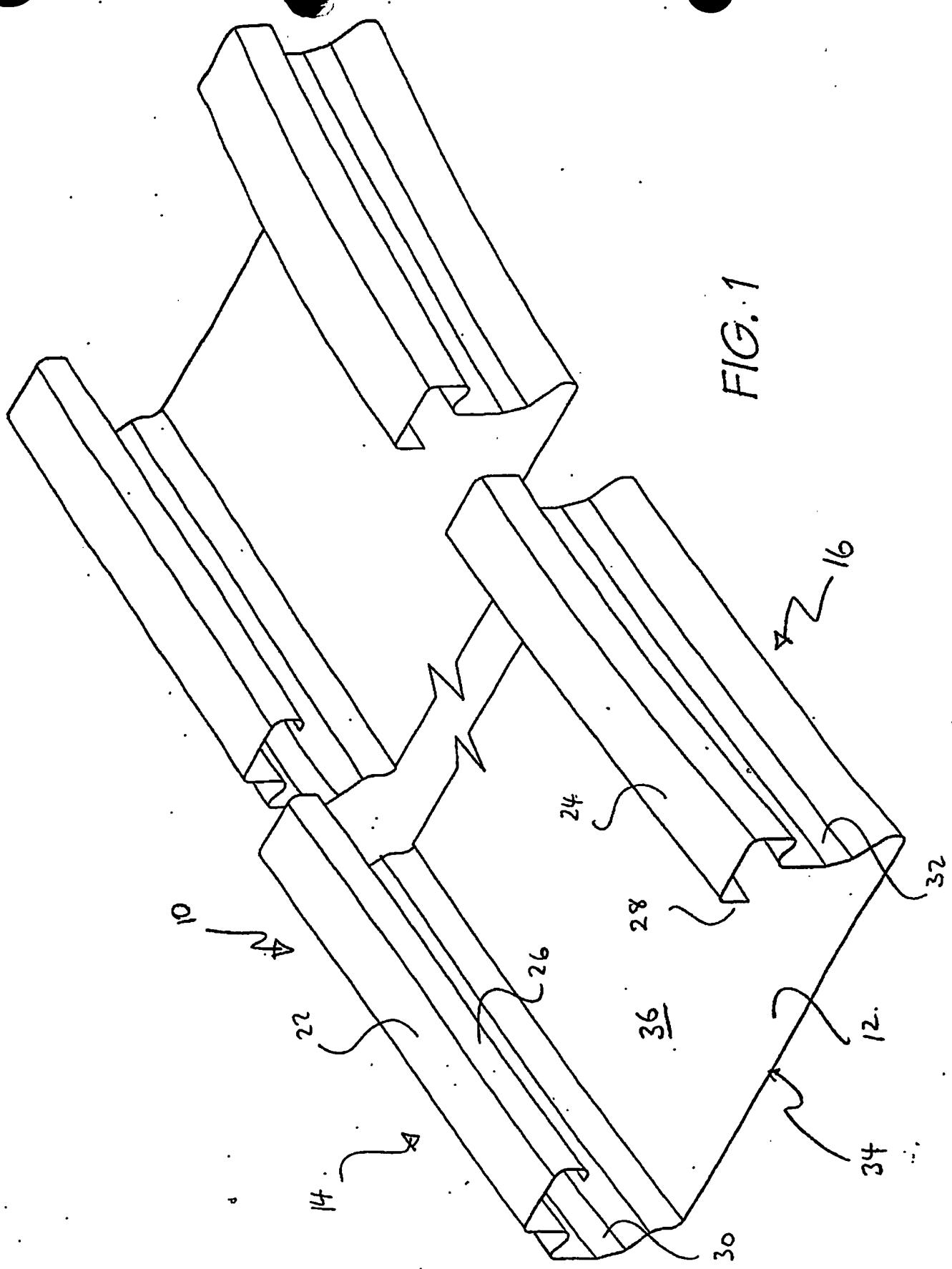
BHP STEEL LIMITED

By their Patent Attorneys

10 GRIFFITH HACK

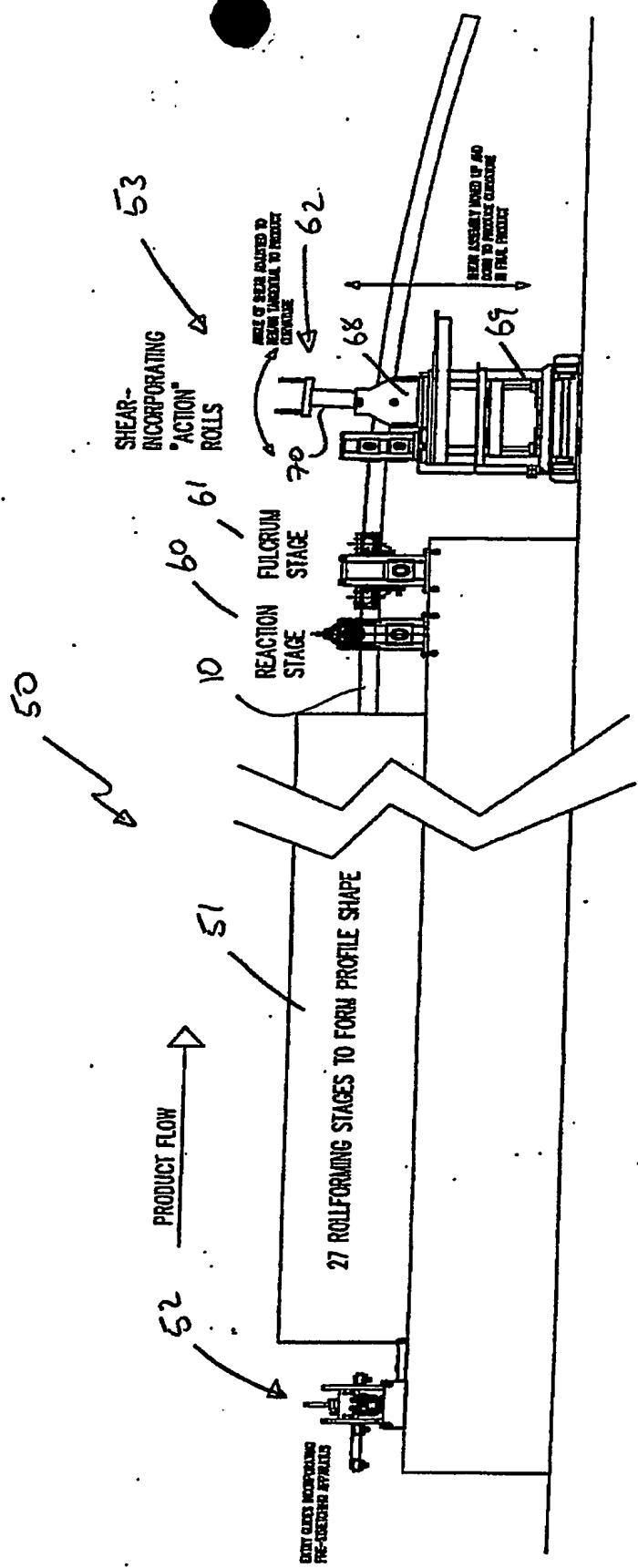
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FIG. 1

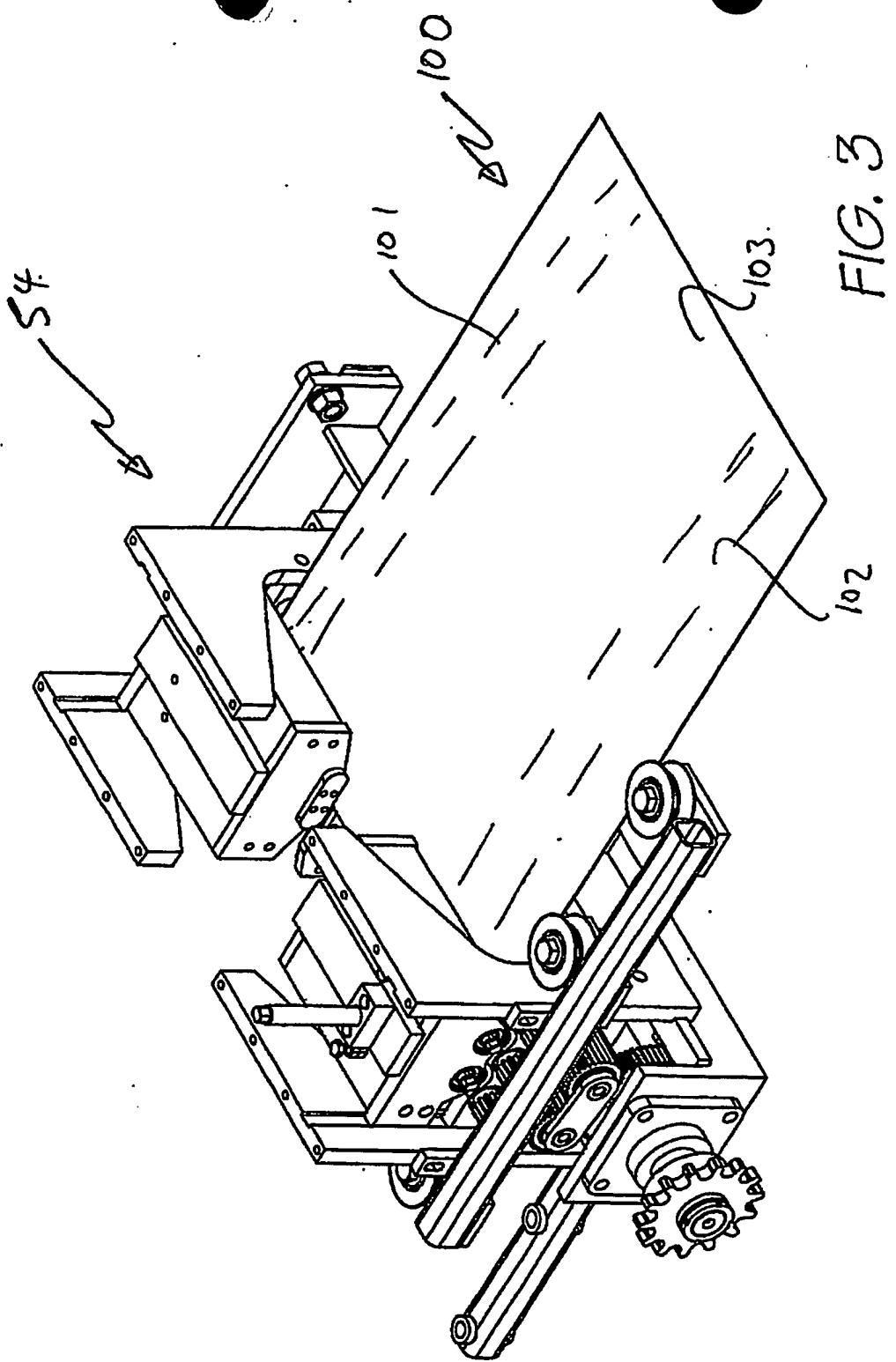


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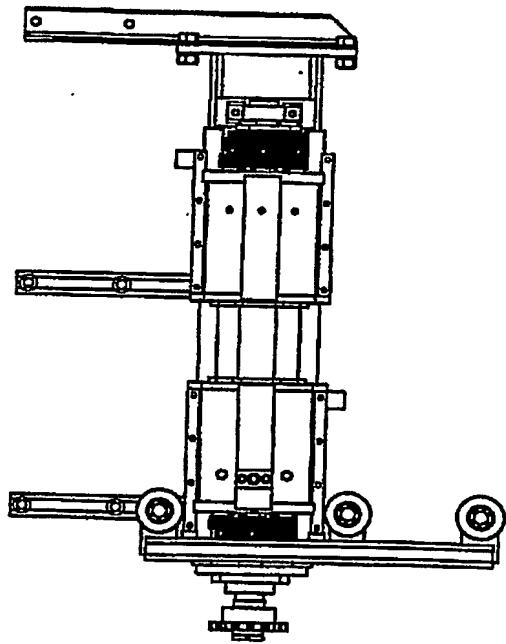
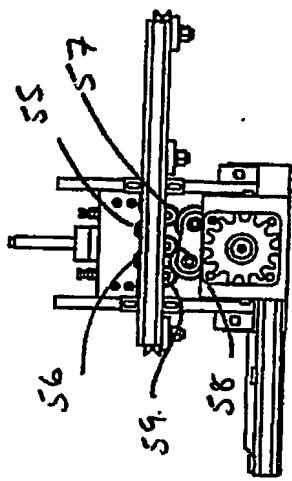
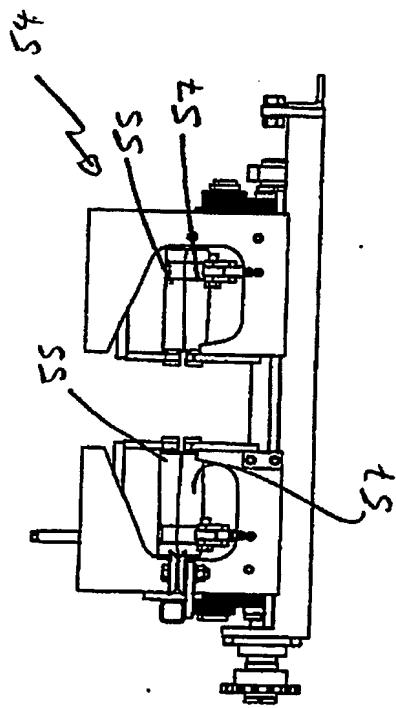
FIG. 2



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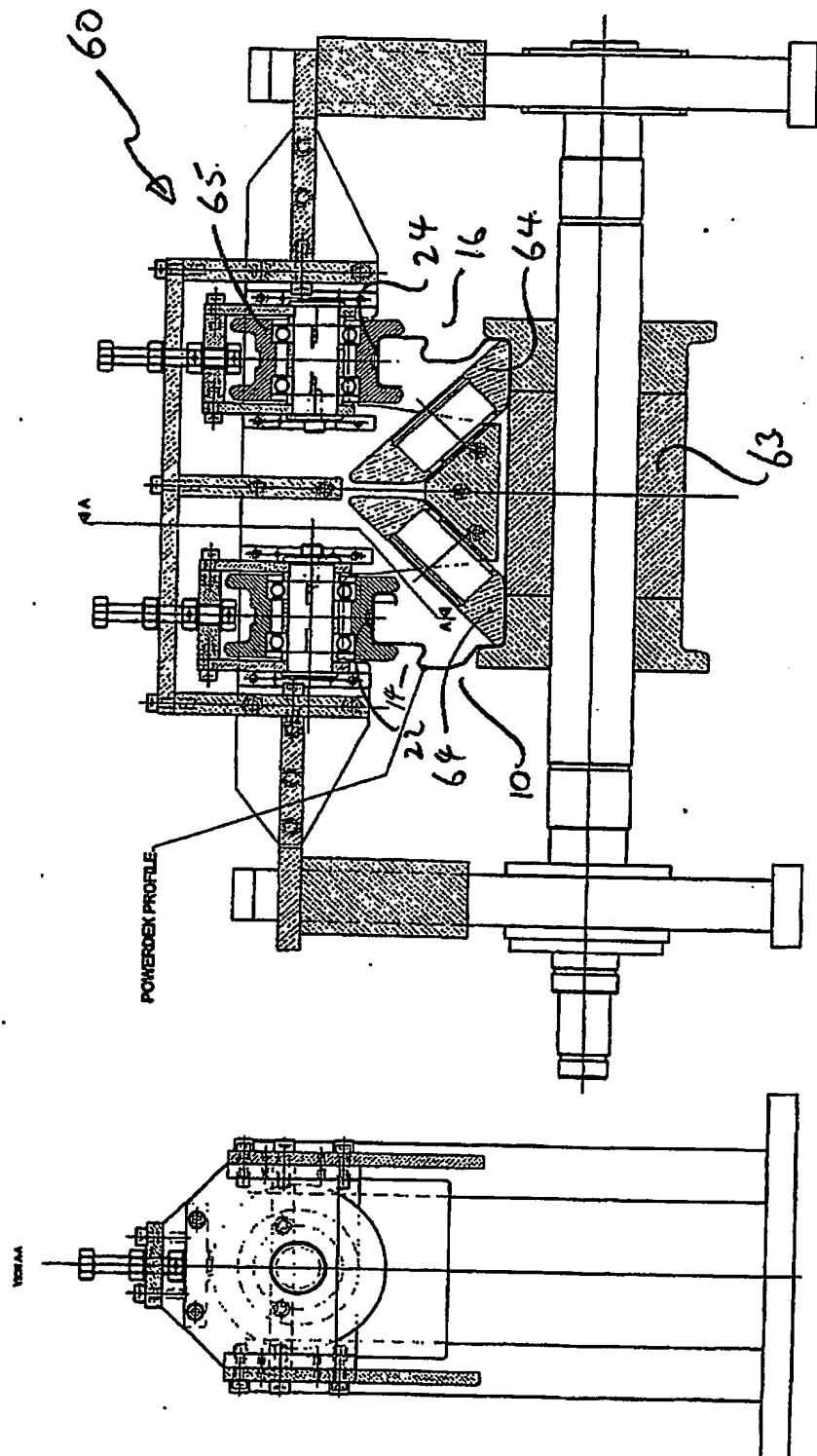
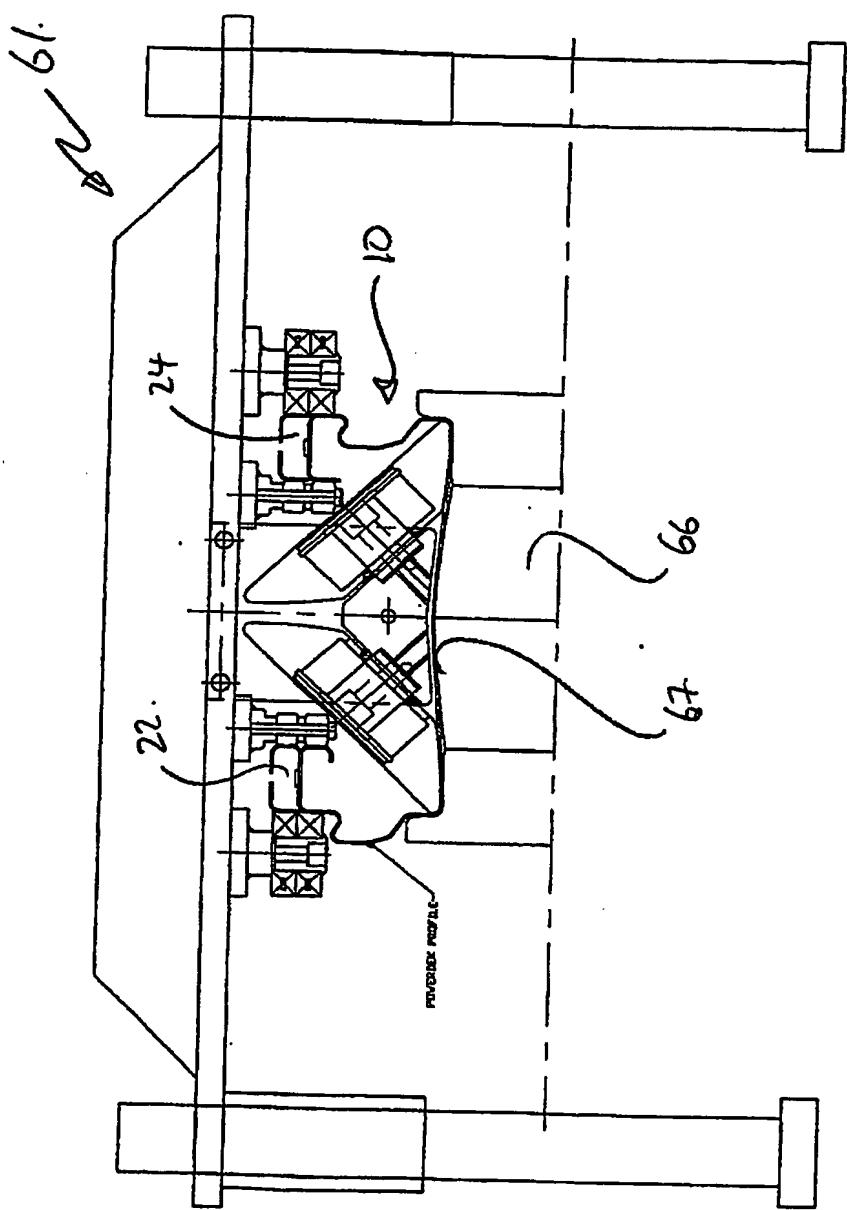


FIG. 6

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FIG. 7



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